

**DEPARTMENT OF TRANSPORTATION****DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-012346**Date Inspected:** 05-Mar-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Zhon Cheng**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Hiranch Patel, was present during the times noted above for observations relative to the work being performed.

**Bay#19**

Weld repair performed FCAW welding of weld joint SB008-036-025 with WRR# B-WR10844 located on suspender bracket SB36. Welder is identified as 062755(2G). ZPMC QC is identified as Zhon Cheng. The welding variables recorded by QC appeared to comply with the Applicable WPS-345-FCAW-2G(2F)-Repair-1.

Weld repair performed FCAW welding of weld joint SB007-038-004 with WRR# B-WR10833 located on suspender bracket SB38. Welder is identified as 062755 (2G). ZPMC QC is identified as Zhon Cheng. The welding variables recorded by QC appeared to comply with the Applicable WPS-345-FCAW-2G(2F)-Repair-1.

Weld repair performed FCAW welding of weld joint SB008-044-005 with WRR# B-WR10822 located on suspender bracket SB44. Welder is identified as 062808 (3G). ZPMC QC is identified as Zhon Cheng. The welding variables recorded by QC appeared to comply with the Applicable WPS-345-FCAW-3G(3F)-Repair.

Weld repair performed FCAW welding of weld joint SB007-046-049 with WRR# B-WR10814 located on suspender bracket SB46. Welder is identified as 062763 (2G). ZPMC QC is identified as Zhon Cheng. The welding variables recorded by QC appeared to comply with the Applicable WPS-345-FCAW-2G(2F)-Repair-1.

Weld repair performed FCAW welding of weld joint SB007-036-025 with WRR# B-WR10804 located on

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suspender bracket SB36. Welder is identified as 062788 (2G). ZPMC QC is identified as Zhon Cheng. The welding variables recorded by QC appeared to comply with the Applicable WPS-345-FCAW-2G(2F)-Repair-1.

Weld repair performed SMAW welding of weld joint SB007-040-018 with WRR# B-WR10840 located on suspender bracket SB36. Welder is identified as 062746 (2G). ZPMC QC is identified as Zhon Cheng. The welding variables recorded by QC appeared to comply with the Applicable WPS-345-SMAW-2G(2F)-Repair-1.

## Bay#15

This QA inspector performed MT of punch list item#224 of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The member is identified as OBG Components. The weld designations reviewed are as follows:

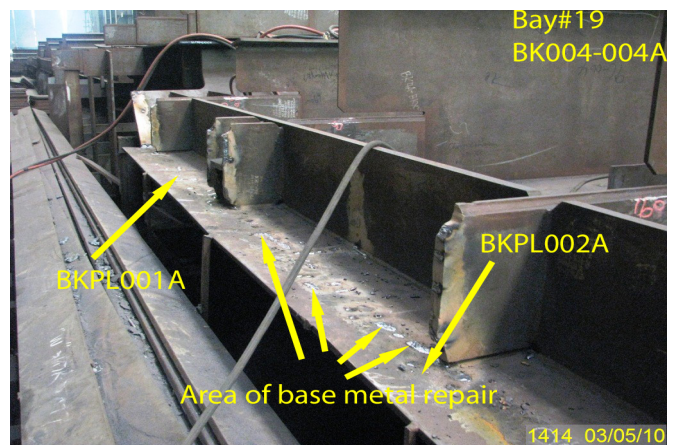
- (CB202G-008-061, 043)
- (CB202G-007-055)
- (CB202G-006-043)
- (CB202G-005-043)

## Bay#19

During random in process inspection of Bike Path, BK4A-004, this QA inspector observed that ZPMC performed base metal repair on BKPL1A and BKPL2A. This base metal repair performed with SMAW welding process, after removing the outer cover plate by carbon arc gouging. ZPMC QC personal does not have Weld Repair Report for this base metal repair and this repair done without inform our engineer.

For further information, please see the attached pictures below.

Unless otherwise noted, all observed on this date appeared to generally comply with applicable contract documents.



## Summary of Conversations:

No relevant conversations.

## Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Patel,Hiranch	Quality Assurance Inspector
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<b>Reviewed By:</b>	McClendon,Timothy	QA Reviewer
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